

Date: Wednesday, 11/03/2009 12:59:25 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ANGLE
<b>Job Number</b> : 46452	
<b>Estimate Number</b> : 13595	
<b>P.O. Number</b> :	<b>Part Number</b> : D38151
<b>This Issue</b> : 11/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3815 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 45832	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 31/03/2009 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JD 09.03.11</u>	
<b>Comment</b> : Est Rev:A 08-09-18 new issue DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S063	2024-T3 .063 sheet
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**Comment:** Qty.: 0.4859 sf(s)/Unit Total: 2.9156 sf(s)  
 2024-T3 .063 sheet  
 batch: 110980

ml 09 03 24

(6)

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3815  
 Dwg Rev: A  
 Prog Rev: A

\*\*\*\*grain direction along 4.30" \*\*\*\*

2-Deburr if necessary

ml 09 03 24 (6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 03 24

(6)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

SB 09/03/24 (6)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
 1- deburr if necessary  
 2- Bend as per Dwg D3815

SB 09/09/05

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 11/03/2009 12:59:25 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 46452

Part Number: D38151

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



(1)

Comment: INSPECT WORK TO CURRENT STEP

SB 09/05/05 (XB)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(XB)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UND/ FR

09/05/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 09-05-5

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: GA

SB 09/05/05 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/05 KJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

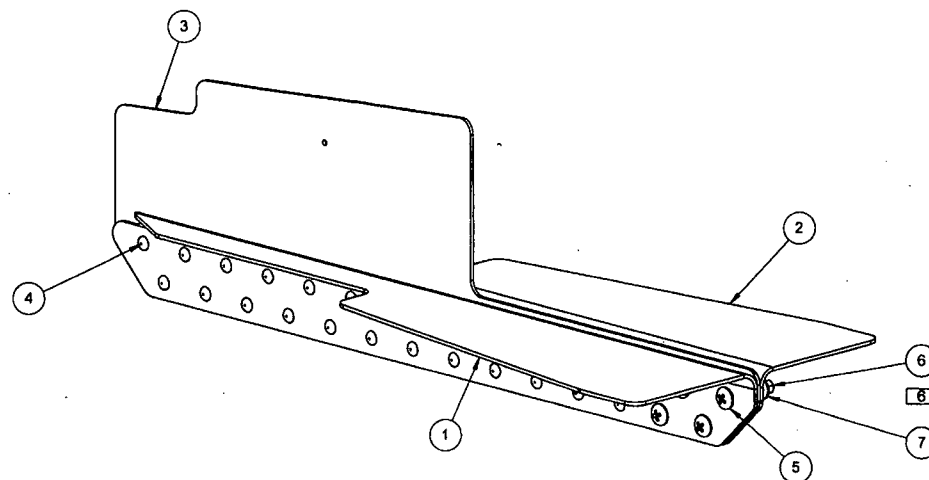
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



C209103/17  
W/O: 46452.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. .041
1	D3815-1	ANGLE	1
2	D3815-2	ANGLE	1
3	D3815-3	WEB	1
4	MS20470AD4-6	RIVET	25
5	AN528C832R14	SCREW	4
6	MS21042L08	NUT	4
7	NAS1149DN832J	WASHER	4

**D3815-041 WEB ASSEMBLY**

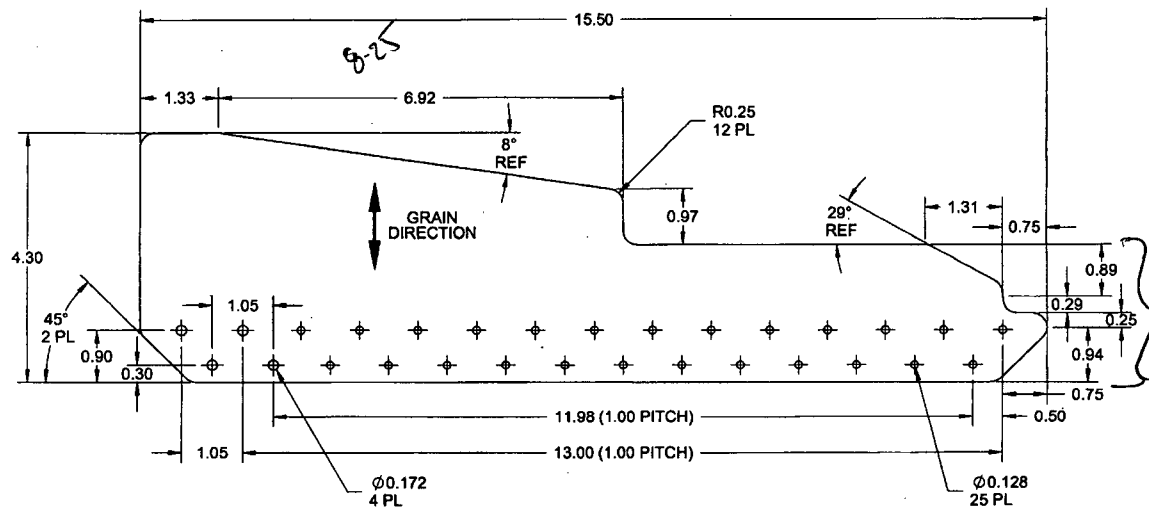
RELEASED  
09/03/17

**NOTES:**

- 1) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-041 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.88 lbs
- 6) INSTALL LOOSE (4 PLACES) AFTER POWDER COAT

A	NEW ISSUE		08.09.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.22		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3815</b>	REV. A
TITLE <b>WEB</b>	SCALE NTS
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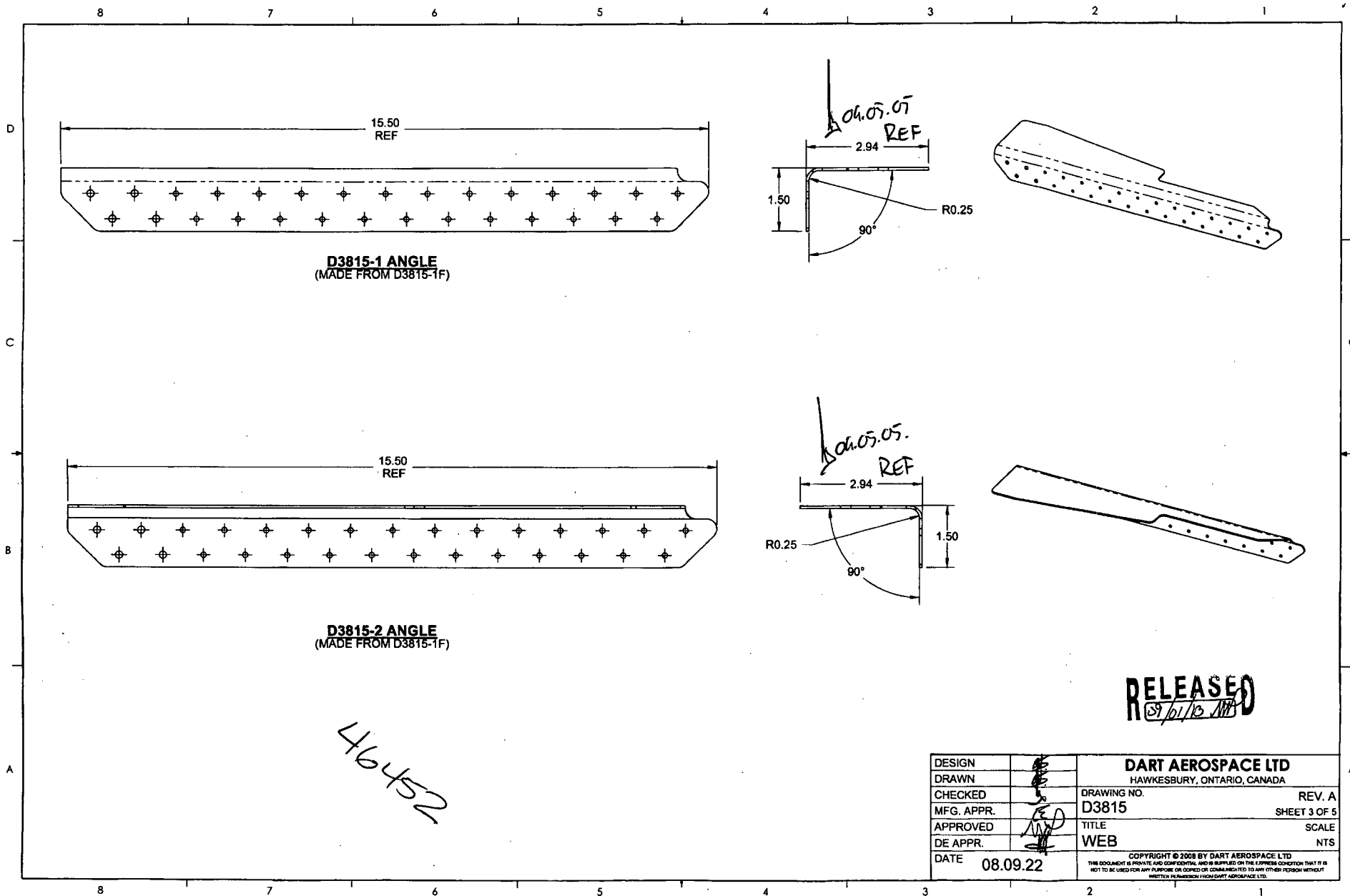
**D3815-1F FLAT PATTERN**

**RELEASED**  
07/01/13

**NOTES:**

- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: N/A
- 5) WEIGHT: 0.29 lbs

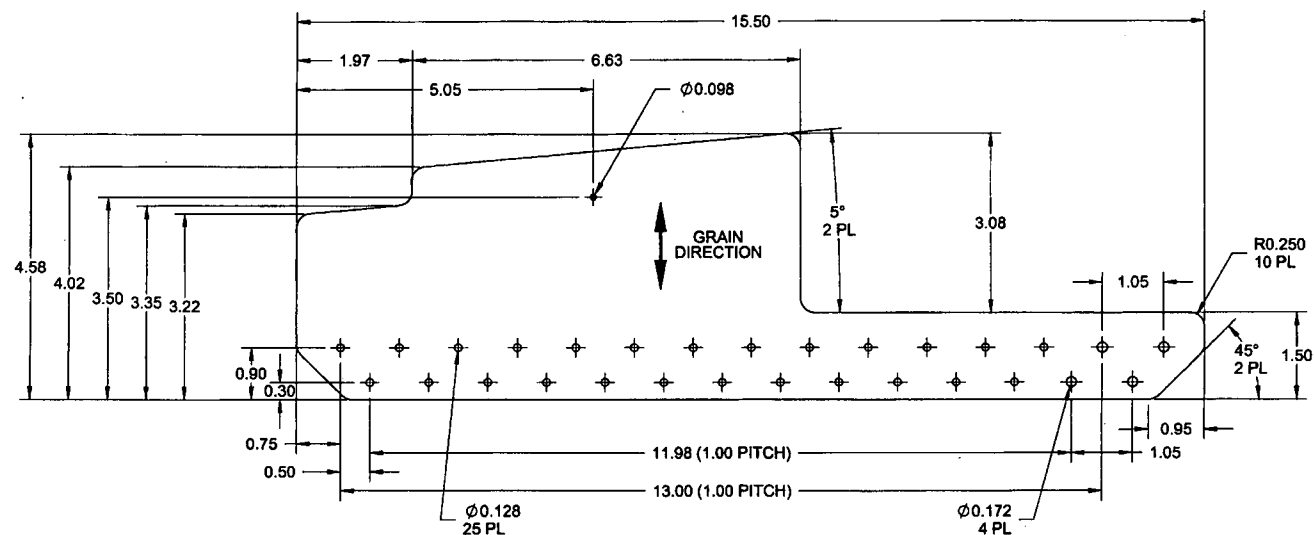
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09/01/03

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**D3815-3 WEB**

46452

**RELEASED**  
09/01/13 MP

**NOTES:**

- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.28 lbs

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